

731-01

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:39:40 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MECHANICAL GROUND HANDLING WHEEL KIT	
Job Number :	47364A			
Estimate Number :	12136			
P.O. Number :		Part Number :	D206731041	
This Issue :	22/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	DSK 093 REV B	
First Issue :	//	Project Number :	N/A	
Previous Run :	47363A	Drawing Revision :	B	
Written By :		Material :		
Checked & Approved By :	JLD 09.04.22	Due Date :	05/06/2009	Qty: 1 Um: Each
Comment :	est rev. A 01.02.01 new issue EC Est Rev:B As per Rev B 07-02-13 JLM est rev C 07.05.14 rev C IIN Ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	B44058

PC09.04.30

2.0	D3353041	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LUG ARM WELDMENT

Batch: B42475

PC09.04.03

3.0	D3354041	Left Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-041	Left Arm Weldment	B36213

B36213

PC09.04.30

4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RIGHT ARM WELDMENT

batch: B42477

PC09.04.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/04/2009 11:39:41 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 47364A

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	<u>B36640</u>

pl09-04-30

6.0

D3397041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	<u>R36529-2</u>

SAD 09-05-03

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	<u>M1010584</u>

pl09-04-30

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	<u>M105735</u>

pl09-04-30

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	<u>M16362</u>

pl09-04-30

Dart Aerospace Ltd

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 47364A

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	<u>M19278</u>

Plc 09.04.30

✓ 11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	<u>M110523</u>

Plc 09.04.30

✓ 12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	CP21	1/8" Cotter Pin 2" long	<u>M108200</u>

Plc 09.04.30

✓ 13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	<u>M109840</u>

Plc 09.04.30

✓ 14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	<u>M102395</u>

Plc 09.04.30

W/O:		WORK ORDER CHANGES					
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Job Number: 47364A

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 15.0 TP2 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	M16588

Pl 09.04.30

✓ 16.0 TP134 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description	batch
1	TP-134	Spring pin	M16362

Pl 09.04.30

17.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Assemble as per dwg DSK 093

SAD 09-05-13 @

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

Pl 09.04.30

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/15 @

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD47364

S 09/05/15 @

20.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/19 JH

Job Completion



MF
09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

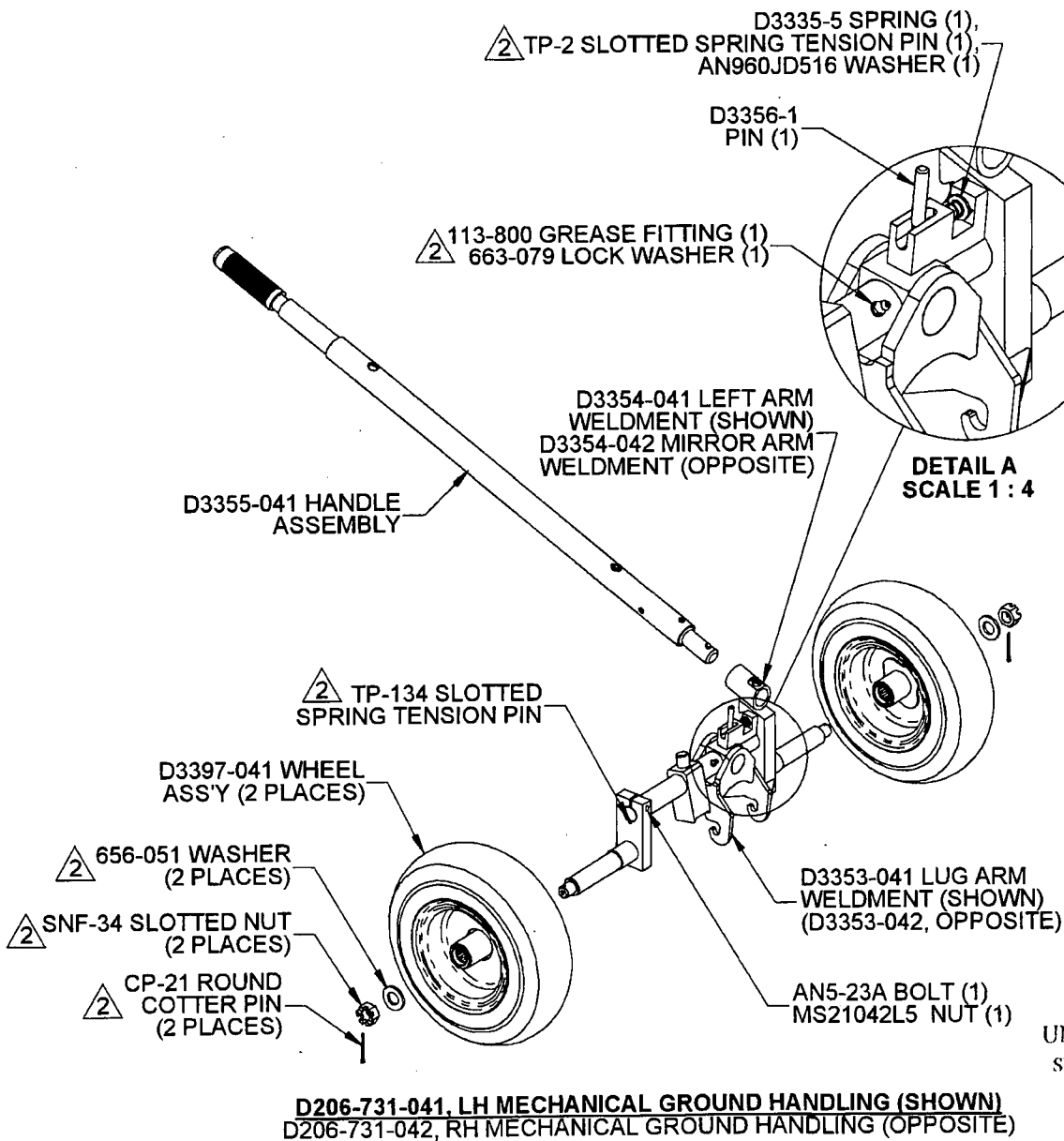
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.02.05

DESIGN <i>RF</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *47364A*

NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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